

WHAT IS CLAIMED IS:

1. An article comprising an ultrasonically bonded laminated structure, the laminated structure comprising a first thermoplastic material, a second thermoplastic material, and an adhesive composition, the adhesive 5 composition comprising an atactic polymer and an isotactic polymer, the atactic polymer having a degree of crystallinity of less than about 20% and a number-average molecular weight of from about 1,000 to about 300,000 and the isotactic polymer having a degree of crystallinity of at least about 10 40% and a number-average molecular weight of from about 3,000 to about 200,000, wherein the first thermoplastic material and the second thermoplastic material are compatible thermoplastic materials and are ultrasonically bonded together.

2. The article as set forth in claim 1 wherein the degree of crystallinity of the atactic polymer is less than about 15%.

3. The article as set forth in claim 1 wherein the degree of crystallinity of the isotactic polymer is at least about 60%.

4. The article as set forth in claim 1 wherein the number-average molecular weight of the atactic polymer is between about 3,000 and about 100,000.

5. The article as set forth in claim 1 wherein the number-average molecular weight of the isotactic polymer is between about 10,000 and about 100,000.

6. The article as set forth in claim 1 wherein the adhesive composition is hot-melt processable at less than about 400 degrees Fahrenheit.

7. The article as set forth in claim 1 wherein the adhesive composition is hot-melt processable at less than about 375 degrees Fahrenheit.

8. The article as set forth in claim 1 wherein the adhesive composition has a melt index of from about 100 to about 2000 grams per 10 minutes.

9. The article as set forth in claim 1 wherein the adhesive composition comprises from about 40 to about 90 weight percent of the atactic polymer and from about 5 to about 30 weight percent of the isotactic polymer.

10. The article as set forth in claim 1 wherein the atactic polymer comprises atactic polypropylene.

11. The article as set forth in claim 1 wherein the atactic polymer is selected from the group consisting of low density polyethylene, atactic polystyrene, atactic polybutene, amorphous polyolefin copolymer, and combinations thereof.

12. The article as set forth in claim 11 wherein the low density polyethylene has a density in the range of 0.910 to 0.935 grams per cubic centimeter.

13. The article as set forth in claim 1 wherein the isotactic polymer comprises isotactic polypropylene.

14. The article as set forth in claim 1 wherein the isotactic polymer is selected from the group consisting of high density polyethylene, isotactic polystyrene, isotactic polybutene, and combinations thereof.

15. The article as set forth in claim 14 wherein the high density polyethylene has a density in the range of 0.935 to 0.980 grams per cubic centimeter.

16. The article as set forth in claim 1 wherein the first thermoplastic material comprises polyethylene and the second thermoplastic material comprises polyethylene.

17. The article as set forth in claim 1 wherein the first thermoplastic material comprises polypropylene and the second thermoplastic material comprises polypropylene.

18. The article as set forth in claim 1 wherein the first thermoplastic material comprises polyester and the second thermoplastic material comprises polyester.

19. The article as set forth in claim 1 wherein the first thermoplastic material comprises rubber and the second thermoplastic material comprises rubber.

20. The article as set forth in claim 1 wherein the first thermoplastic material comprises polylactic acid and the second thermoplastic material comprises polylactic acid.

21. The article as set forth in claim 1 wherein the first thermoplastic material comprises nylon and the second thermoplastic material comprises nylon.

22. The article as set forth in claim 1 wherein the first thermoplastic material comprises polystyrene and the second thermoplastic material comprises polystyrene.

23. The article as set forth in claim 1 wherein the adhesive composition additionally comprises a further component selected from the group consisting of tackifiers, antioxidants, viscosity modifiers, color pigments, fillers, and polymeric compatibilizers.

24. A process for manufacturing an article comprising an ultrasonically bonded laminated structure, the process comprising:

5 providing a first thermoplastic substrate comprising an adhesive composition, the adhesive composition comprising an atactic polymer and an isotactic polymer, the atactic polymer having a degree of crystallinity of less than about 20% and a number-average molecular weight of from about 1,000 to about 300,000 and the isotactic polymer having a degree of
10 crystallinity of at least about 40% and a number-average molecular weight of from about 3,000 to about 200,000;

providing a second thermoplastic substrate compatible with the first thermoplastic substrate; and

15 ultrasonically bonding the first thermoplastic substrate to the second thermoplastic substrate.

25. The process as set forth in claim 24 wherein the degree of crystallinity of the atactic polymer is less than about 15%.

26. The process as set forth in claim 24 wherein the degree of crystallinity of the isotactic polymer is at least about 60%.

27. The process as set forth in claim 24 wherein the number-average molecular weight of the atactic polymer is between about 3,000 and about 100,000.

28. The process as set forth in claim 24 wherein the number-average molecular weight of the isotactic polymer is between about 10,000 and about 100,000.

29. The process as set forth in claim 24 wherein the adhesive composition is hot-melt processable at less than about 400 degrees Fahrenheit.

30. The process as set forth in claim 24 wherein the adhesive composition is hot-melt processable at less than about 375 degrees Fahrenheit.

31. The process as set forth in claim 24 wherein the adhesive composition has a melt index of from about 100 to about 2000 grams per 10 minutes.

32. The process as set forth in claim 24 wherein the adhesive composition comprises from about 40 to about 90 weight percent of the atactic polymer and from about 5 to about 30 weight percent of the isotactic polymer.

33. The process as set forth in claim 24 wherein the atactic polymer comprises atactic polypropylene.

34. The process as set forth in claim 24 wherein the atactic polymer is selected from the group consisting of low density polyethylene, atactic polystyrene, atactic polybutene, amorphous polyolefin copolymer, and combinations thereof.

35. The process as set forth in claim 34 wherein the low density polyethylene has a density in the range of 0.910 to 0.935 grams per cubic centimeter.

36. The process as set forth in claim 24 wherein the isotactic polymer comprises isotactic polypropylene.

37. The process as set forth in claim 24 wherein the isotactic polymer is selected from the group consisting of high density polyethylene, isotactic polystyrene, isotactic polybutene, and combinations thereof.

38. The process as set forth in claim 37 wherein the high density polyethylene has a density in the range of 0.935 to 0.980 grams per cubic centimeter.

39. The process as set forth in claim 24 wherein the first thermoplastic material comprises polyethylene and the second thermoplastic material comprises polyethylene.

40. The process as set forth in claim 24 wherein the first thermoplastic material comprises polypropylene and the second thermoplastic material comprises polypropylene.

41. The process as set forth in claim 24 wherein the first thermoplastic material comprises polyester and the second thermoplastic material comprises polyester.

42. The process as set forth in claim 24 wherein the first thermoplastic material comprises rubber and the second thermoplastic material comprises rubber.

43. The process as set forth in claim 24 wherein the first thermoplastic material comprises polylactic acid and the second thermoplastic material comprises polylactic acid.

44. The process as set forth in claim 24 wherein the first thermoplastic material comprises nylon and the second thermoplastic material comprises nylon.

45. The process as set forth in claim 24 wherein the first thermoplastic material comprises polystyrene and the second thermoplastic material comprises polystyrene.

46. The process as set forth in claim 24 wherein the adhesive composition additionally comprises a further component selected from the group consisting of tackifiers, antioxidants, color pigments, viscosity modifiers, fillers, and polymeric compatibilizers.

47. A process for manufacturing an article comprising an ultrasonically bonded laminated structure, the process comprising:

- 5 providing a first thermoplastic substrate;
- 5 providing a second thermoplastic substrate compatible with the first thermoplastic substrate;

introducing an adhesive composition onto the first or second thermoplastic substrate and contacting the first and second substrate together to form an adhesive bond

10 therebetween, the adhesive composition comprising an atactic polymer and an isotactic polymer, the atactic polymer having a degree of crystallinity of less than about 20% and a number-average molecular weight of from about 1,000 to about 300,000 and the isotactic polymer having a degree of
15 crystallinity of at least about 40% and a number-average molecular weight of from about 3,000 to about 200,000; and ultrasonically bonding the first thermoplastic substrate to the second thermoplastic substrate.

48. The process as set forth in claim 47 wherein the degree of crystallinity of the atactic polymer is less than about 15%.

49. The process as set forth in claim 47 wherein the degree of crystallinity of the isotactic polymer is at least about 60%.

50. The process as set forth in claim 47 wherein the number-average molecular weight of the atactic polymer is between about 3,000 and about 100,000.

51. The process as set forth in claim 47 wherein the number-average molecular weight of the isotactic polymer is between about 10,000 and about 100,000.

52. The process as set forth in claim 47 wherein the adhesive composition is hot-melt processable at less than about 400 degrees Fahrenheit.

53. The process as set forth in claim 47 wherein the adhesive composition is hot-melt processable at less than about 375 degrees Fahrenheit.

54. The process as set forth in claim 47 wherein the adhesive composition has a melt index of from about 100 to about 2000 grams per 10 minutes.

55. The process as set forth in claim 47 wherein the adhesive composition comprises from about 40 to about 90 weight percent of the atactic polymer and from about 5 to about 30 weight percent of the isotactic polymer.

56. The process as set forth in claim 47 wherein the atactic polymer comprises atactic polypropylene.

57. The process as set forth in claim 47 wherein the atactic polymer is selected from the group consisting of low density polyethylene, atactic polystyrene, atactic polybutene, amorphous polyolefin copolymer, and combinations thereof.

58. The process as set forth in claim 57 wherein the low density polyethylene has a density in the range of 0.910 to 0.935 grams per cubic centimeter.

59. The process as set forth in claim 47 wherein the isotactic polymer comprises isotactic polypropylene.

60. The process as set forth in claim 47 wherein the isotactic polymer is selected from the group consisting of high density polyethylene, isotactic polystyrene, isotactic polybutene, and combinations thereof.

61. The process as set forth in claim 60 wherein the high density polyethylene has a density in the range of 0.935 to 0.980 grams per cubic centimeter.

62. The process as set forth in claim 47 wherein the first thermoplastic material comprises polyethylene and the second thermoplastic material comprises polyethylene.

63. The process as set forth in claim 47 wherein the first thermoplastic material comprises polypropylene and the second thermoplastic material comprises polypropylene.

64. The process as set forth in claim 47 wherein the first thermoplastic material comprises polyester and the second thermoplastic material comprises polyester.

65. The process as set forth in claim 47 wherein the first thermoplastic material comprises rubber and the second thermoplastic material comprises rubber.

66. The process as set forth in claim 47 wherein the first thermoplastic material comprises polylactic acid and the second thermoplastic material comprises polylactic acid.

67. The process as set forth in claim 47 wherein the first thermoplastic material comprises nylon and the second thermoplastic material comprises nylon.

68. The process as set forth in claim 47 wherein the first thermoplastic material comprises polystyrene and the second thermoplastic material comprises polystyrene.

69. The process as set forth in claim 47 wherein the adhesive composition additionally comprises a further component selected from the group consisting of tackifiers, antioxidants, color pigments, viscosity modifiers, fillers, and polymeric compatibilizers.

70. An article comprising an ultrasonically bonded laminated structure, the laminated structure comprising a first thermoplastic material, a second thermoplastic material, and an adhesive composition, the adhesive composition comprising an atactic polymer and an isotactic polymer, the atactic polymer having a degree of crystallinity

of less than about 20% and a number-average molecular weight of from about 1,000 to about 300,000 and the isotactic polymer having a degree of crystallinity of at least about 10 40% and a number-average molecular weight of from about 3,000 to about 200,000, wherein the first thermoplastic material and the second thermoplastic material are compatible thermoplastic materials and are ultrasonically bonded together, and wherein the adhesive composition has an open 15 time of less than about 10 minutes.

71. The article as set forth in claim 70 wherein the degree of crystallinity of the atactic polymer is less than about 15%.

72. The article as set forth in claim 70 wherein the degree of crystallinity of the isotactic polymer is at least about 60%.

73. The article as set forth in claim 70 wherein the number-average molecular weight of the atactic polymer is between about 3,000 and about 100,000.

74. The article as set forth in claim 70 wherein the number-average molecular weight of the isotactic polymer is between about 10,000 and about 100,000.

75. The article as set forth in claim 70 wherein the adhesive composition is hot-melt processable at less than about 400 degrees Fahrenheit.

76. The article as set forth in claim 70 wherein the adhesive composition is hot-melt processable at less than about 375 degrees Fahrenheit.

77. The article as set forth in claim 70 wherein the adhesive composition has a melt index of from about 100 to about 2000 grams per 10 minutes.

78. The article as set forth in claim 70 wherein the adhesive composition comprises from about 40 to about 90 weight percent of the atactic polymer and from about 5 to about 30 weight percent of the isotactic polymer.

79. The article as set forth in claim 70 wherein the atactic polymer comprises atactic polypropylene.

80. The article as set forth in claim 70 wherein the atactic polymer is selected from the group consisting of low density polyethylene, atactic polystyrene, atactic polybutene, amorphous polyolefin copolymer, and combinations thereof.

5 81. The article as set forth in claim 80 wherein the low density polyethylene has a density in the range of 0.910 to 0.935 grams per cubic centimeter.

82. The article as set forth in claim 70 wherein the isotactic polymer comprises isotactic polypropylene.

83. The article as set forth in claim 70 wherein the isotactic polymer is selected from the group consisting of high density polyethylene, isotactic polystyrene, isotactic polybutene, and combinations thereof.

84. The article as set forth in claim 83 wherein the high density polyethylene has a density in the range of 0.935 to 0.980 grams per cubic centimeter.

85. The article as set forth in claim 70 wherein the first thermoplastic material comprises polyethylene and the second thermoplastic material comprises polyethylene.

86. The article as set forth in claim 70 wherein the first thermoplastic material comprises polypropylene and the second thermoplastic material comprises polypropylene.

87. The article as set forth in claim 70 wherein the first thermoplastic material comprises polyester and the second thermoplastic material comprises polyester.

88. The article as set forth in claim 70 wherein the first thermoplastic material comprises rubber and the second thermoplastic material comprises rubber.

89. The article as set forth in claim 70 wherein the first thermoplastic material comprises polylactic acid and the second thermoplastic material comprises polylactic acid.

90. The article as set forth in claim 70 wherein the first thermoplastic material comprises nylon and the second thermoplastic material comprises nylon.

91. The article as set forth in claim 70 wherein the first thermoplastic material comprises polystyrene and the second thermoplastic material comprises polystyrene.

92. The article as set forth in claim 70 wherein the adhesive composition additionally comprises a further component selected from the group consisting of tackifiers, antioxidants, color pigments, viscosity modifiers, fillers, and polymeric compatibilizers.

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